

Work Order ID 140889

Friday, January 22, 2016 9:51:16 AM

140889

Page 1

Item ID: D412-704-015

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Co-Pilot's Emergency Cargo Release

Stop ***NS2***

Start Date: 1/22/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/5/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: JAN 22 2016 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-704	D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-704-015 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MAR 3 2016

MAR 15 2016

MAR 3 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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Item ID: D412-704-015 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Co-Pilot's Emergency Cargo Release
Start Date: 1/22/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/5/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-704-015 Location: _____ PPP Rev: _____								
		Sold							
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

27
8-09
MAR 3 4 2016

16/3/30
mf
(6-3-30)

Checklist Print

Friday, January 22, 2016 9:51:19 AM

Page 1

Work Order ID: 140889

140889

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 1/22/2016

Required Date: 2/5/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-03-22 JLM VERIFIED BY:EC
REV:B 12.04.20 per cen-566 DD verf:EC
12.05.10 per ECN 12-583 DD verf:EC
IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D412-704-141

Manufactured No

110

Each

0.0000

1

1

D412-704-141

Pedal Assembly

D412-704-045

Manufactured No

110

Each

3.0000

1

1

D412-704-045

Cable Ass'y

Location

Loc Qty

Loc Code

ST215

3

136529

2

139542

1

D3207-5

Manufactured No

110

Each

18.0000

1

1

D3207-5

Bracket

Location

Loc Qty

Loc Code

ST024

18

116991

18

D3207-7

Manufactured No

110

Each

17.0000

1

1

D3207-7

Packer

Location

Loc Qty

Loc Code

ST024

17

110077

17

MAR 15 2016

Clicklist Print

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Work Order ID: 140889

Parent Item: D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

140889

D412-704-015

Start Date: 1/22/2016

Required Date: 2/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3207-9
D3207-9

Bracket

Manufactured No

110 Each

9.0000

1

**

DAS
28
6
9-89

Location

Loc Qty

Loc Code

ST024

9

122604

9

D3208-1
D3208-1

Doubler

Manufactured No

110 Each

6.0000

1 1

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST025

6

124260

6

D3208-11
D3208-11

Filler

Manufactured No

110 Each

3.0000

1 1

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST026

3

122473

3

D3208-3
D3208-3

Pedal Mount Angle

Manufactured No

110 Each

11.0000

1

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST025

11

117181

11

D3208-7
D3208-7

Filler

Manufactured No

110 Each

12.0000

1

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST025

12

119559

12

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 140889

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Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 1/22/2016

Required Date: 2/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3208-9
D3208-9
Doubler

Manufactured No

110 Each

3.0000

1 1
**

DAS
6 28
9-89

Location

Loc Qty

Loc Code

ST025

3

126281

3

D3214-1
D3214-1
Decal

Manufactured No

110 Each

5.0000

1
**

DAS
6 28
9-89

Location

Loc Qty

Loc Code

ST026

5

131887

5

D4610-1
D4610-1
Doubler

Manufactured No

110 Each

12.0000

1
**

DAS
6 28
9-89

Location

Loc Qty

Loc Code

ST112

12

119696

12

D4610-3
D4610-3
Doubler

Manufactured No

110 Each

1.0000

1
**

DAS
6 28
9-89

Location

Loc Qty

Loc Code

ST112

1

98863

1

D4610-7
D4610-7
Cover

Manufactured No

110 Each

1.0000

1
**

DAS
6 28
9-89

Location

Loc Qty

Loc Code

ST112

1

131891

1

MAR 15 2016

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Shop Packet Print

Page 3

Picklist Print

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Work Order ID: 140889

140889

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 1/22/2016

Required Date: 2/5/2016

Start Qty: 1.00

Required Qty: 1.00

MS21919-DG5

Purchased

No

110

Each

28.0000

MS21919-DG5

Clamp

**

4

16984

DAS

6

9-89

DAS

28

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST293

10

m133938

10

ST297

18

m129499

18

D4622-1

Manufactured

No

110

Each

8.0000

D4622-1

Placard

**

1

DAS

6

9-89

DAS

28

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

st113

8

132587

8

D4622-3

Manufactured

No

110

Each

10.0000

D4622-3

Placard

**

1

DAS

6

9-89

DAS

28

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

st113

10

132697

10

MS35489-149

Purchased

No

110

Each

90.0000

MS35489-149

GROMMET

**

1

DAS

6

9-89

DAS

28

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST269

90

121692

90

Work Order ID 140889

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Page 1

Item ID: D412-704-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 1/22/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJDate: JAN 22 2016 Tooling:

Date:

Run Start ***NR1***

QC: _____

Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

IIN-D412-704

D

100	Document Control	0.00
-----	------------------	------

100

DC	Memo	0.00
----	------	------

Doc.Control -USB or Paperwork Photocopy bluefile and create labels per PPP D412-704-015 CHG002

MLJ MAR 15 2016

110	Pick Kit	0.00
-----	----------	------

110

Packaging	Memo	0.00
-----------	------	------

Packaging

MAR 15 2016

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

120

QC	Memo	0.00
----	------	------

Quality Control

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D412-704

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
X							D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (210/212/214)
	X						D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (205)
		X					D412-704-015	COPILOT'S EMERGENCY CARGO RELEASE KIT (412)
1	1		X				D412-704-041	PEDAL ASSEMBLY (205/210/212/214)
		1		X			D412-704-141	PEDAL ASSEMBLY (412)
	1				X		D205-704-043	CABLE ASSEMBLY (205)
1		1				X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
			1	1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
			1	1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
			1	1			D3205-3	BACK PLATE (OR ECM 999709-5)
			1	1			D3206-1	PEDAL ARM (OR ECM 999704-1)
	1						D3207-1	BRACKET
	1						D3207-3	BRACKET
1		1					D3207-5	BRACKET
1	1	1					D3207-7	PACKER
		1					D3207-9	BRACKET
1							D3207-11	BRACKET
1	1	1					D3208-1	DOUBLER (OR ECM 999709-1)
1	1	1					D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1						D3208-5	MOUNT ANGLE
1	1	1					D3208-7	FILLER (OR ECM 999709-3)
1		1					D3208-9	DOUBLER
1		1					D3208-11	FILLER
			1	1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1	1					D3214-1	PLACARD (OR ECM 999712-1)
					1		D3217-1	CABLE
						1	D3217-3	CABLE
					1	1	D3257-1	FITTING
					1	1	D3258-1	ANGLE BRACKET
		1					D4610-1	DOUBLER
		1					D4610-3	DOUBLER
			1	1			D4610-5	SHIM
							D4610-7	COVER
				1			D4611-1	BUSHING
		1					D4622-1	PLACARD
		1					D4622-3	PLACARD
			1	1	1	1	AN3-10A	BOLT
			1	1			AN315-4R	NUT
					1	1	AN3-5A	BOLT
			2	2			AN3-6A	BOLT
			1	1			AN4-10A	BOLT
			2				AN4-11A	BOLT
				2			AN4-12A	BOLT
			1				AN4-13A	BOLT
				1			MS20002-4	WASHER

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Revision: D
Date: 14.12.02

REFERENCE ONLY

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Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
				1			MS20004-24	BOLT
			3	3	2	2	MS21042L3	NUT (OR MS21042-3)
			5	5			MS21042L4	NUT (OR MS21042-4)
4	4	4					MS21919DG5	CLAMP
			1				MS24694-S102	SCREW
				1			MS24694-S104	SCREW
	2						MS35489-10	GROMMET
		1					MS35489-149	GROMMET
			1	1			MS9519-10	BOLT
			4	4	2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
			5	5	2	2	NAS1149D0363J	WASHER (OR AN960JD10)
			3	2			NAS1149D0416J	WASHER (OR AN960JD416L)
			14	13			NAS1149D0463J	WASHER (OR AN960JD416)
					3	3	NAS509-3	NUT

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Revision: D

Date: 14.12.02